

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022867**Date Inspected:** 23-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** An Qing Xiang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the Self-Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay 14

OBG Seg 14W:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3020AG-001 [Deck Plate PL3491A of Deck Panel (DP) 3183A to Edge Panel (EP) 3030A, Complete Joint Penetration (CJP) weld at Panel Point (PP) 125]. The welder is identified as 067764 and was observed welding in 4G position. ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-Tc-U4b-FCM-1.

The Submerged Arc Welding (SAW) process on weld joint no: SEG3020\*-011 [DP 3177A to DP 3183A, CJP weld]. The welder is identified as 045270 and was observed welding in 1G position. ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: B-T-223(2)1T-ESAB-1.

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The Flux Cored Arc Welding (FCAW) process on weld joint no: SEG3020V-028 [DP diaphragm of DP 3168A to DP diaphragm of DP 3169A, CJP weld at PP125]. The welder is identified as 045175 and was observed welding in 3G position. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

The FCAW process on weld joint no: SEG3020AB-014 [DP diaphragm of DP 3174A to Longitudinal Diaphragm (LD) 3048A, CJP weld at PP127 to PP127.3]. The welder is identified as 066881 and was observed welding in 2G position. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-T-2232-ESAB.

The FCAW process on weld joint no: SEG3020L-031 [DP diaphragm of DP 3172A to DP diaphragm of DP 3173A, CJP weld at PP127]. The welder is identified as 058245 and was observed welding in 3G position. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

The SMAW process on weld joint no: SEG3020M-206 [Floor Beam (FB) 3327A to deck plate PL3491A of DP 3183A, CJP weld at PP127]. The welder is identified as 066361 and was observed welding in 4G position. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-Tc-U4b-FCM-1.

The SMAW process on weld joint no: SEG3020U-587 [Side Plate (SP) to Anchor Plate (AP) 3032A, CJP weld at PP126]. The welder is identified as 045246 and was observed welding in 3G position. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2213-Tc-U4b-FCM-1.

The SMAW process on weld joint no: SEG3020H-002, 151 and 153 [Edge Plate (EP) to FB diaphragm, fillet weld at PP127.5]. The welder is identified as 067610 and was observed welding in 4F position. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2114-FCM-1.

The SMAW process on weld joint no: SEG3020\*-017 [EP 3030E to deck plate 3491B of DP3183A, CJP weld at PP128 to PP128.3]. The welder is identified as 037748 and was observed welding in 4G position. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-Tc-U4b-FCM-1.

The FCAW process on weld joint no: SEG3020\*-002 [DP 3168A to DP 3169A, CJP weld]. The welders are identified as 045280 and 066239 and were observed welding in 1G position. ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: B-T-223(2)1T-ESAB-1.

The FCAW process on weld joint no: DP3172-001-389 [DP diaphragm X4857D to DP diaphragm X4882H of DP 3172A, CJP weld at PP128.3]. The welder is identified as 067949 and was observed welding in 3G position. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Gaikwad,Umesh	Quality Assurance Inspector
<b>Reviewed By:</b>	Peterson,Art	QA Reviewer

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